Date:

Tuesday, 22/04/2008 10:27:08 AM

User:

Julie Lecoca

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

S.O. No. :

: 38724

Job Number **Estimate Number** : 10175

P.O. Number

Prsht Rev.

First Issue

Comment

Previous Run

This Issue

: 22/04/2008 : NC

: // : 38391

: MACHINED PARTS Type

Part Number

Drawing Name

: D2570

: BUSHING

: 15/05/2008

Drawing Number

D2570 REV B

Project Number

: N/A : B

Drawing Revision

Material **Due Date**

Qty:

500 Um:

Each

Written By

Checked & Approved By

: Est E 02.08.29

Re-format; Removed finishing; Material change K

J

est F 07.07.06

rev B dwa

EC

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M303R0750

303 Round Bar .75"

Comment: Qty.:

40.4775 f(s)

Material: Ø0.750 AISI 303 SS Rod (M303R0.750)

Batch M1025/4

2.0

HARDINGE

HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

Machine as per folio FA198

Deburr



3.0

√QC2



Comment: INSPECT PARTS AS THEY COME OFF MACHINE



4.0

QC8

SECOND CHECK



Comment: SECOND CHECK



5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock Location:

Dart Aerospace Ltd

	WORK ORDER CHANGES						
STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
	STEP					Approval	

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
			QA: N/C Closed:	Date:

NCR: WORK ORDER NON-CONFORMANC					CE (NCR)		Sį.	
		Description of NC		Corrective Action Section B		Verification	Approval	Annroyal
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector
2								
i.								

NOTE: Date & initial all entries

Date:

Tuesday, 22/04/2008 10:27:08 AM

User:

Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 38724

Part Number: D2570

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/30 Jg

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		

Part No:	PAR #:	_ Fault Category:	NCR: Yes	lo DQA:	Date:
			QA: N/	C Closed:	Date:

		WORK ORDER NON-CONFORMANCE (NCR)								
_	STED Description of NC			Corrective Action Section B		Verification	Approval	Approval		
S	TEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspecto		
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NOTE: Date & initial all entries

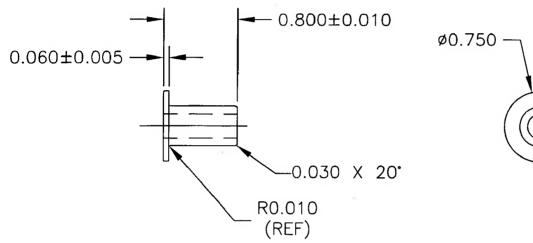
Work Order:	38724
Part Number:	D2570
	Page 1 of 1
	Work Order: Part Number:

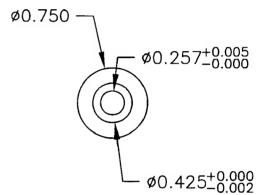
		FIRS ⁻	T ARTICLE IN	ISPECTI	ON CHI	ECKLIST		
		x	First Artic	cle 🕒	Prot	otype		
Draw Dimer	=	Tolerance	Actual Dimension	Accept	Reject	Method o		mments
0.8	00	+/-0.010	,801"					
0.0	60	+/-0.005	061"					
R0.0	010	+0.010/-0.000	Ba 210'					
Ø0.4	425	+0.000/-0.002	d 424"					
Ø0.2	257	+0.005/-0.000	0,259"					
Ø0.7	750	+/-0.010	Ø 745°					
0.030	x 20°	+/-0.010	10.30, x30,					
 -								
								14.
								-
Measure	ed by:	T.F./MME	Audited by:	201	/	Prototype	Approval:	N/A
	Date:	8/04/24	Date:	8/04	124	*	Date:	
Rev	Date	Change		6			Revised by	Approved
A 03	3.12.08	New Issue		,			KJ/RF	
B 04	B 04.02.23 Tolerance for Ø0.425 changed KJ/RF							

Rev	Date	Change	Revised by	Approved
_ A	03.12.08	New Issue	KJ/RF	
В	04.02.23	Tolerance for Ø0.425 changed	KJ/RF	
С	07.07.17	Dimensions updated per Dwg Rev. B	KJ/JLM ok	E



	DESIGN DRAWN BY			DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
	CHEC	KED	APPROVED J	DRAWING NO. REV. B
		世	The state of	D2570 SHEET 1 OF 1
i	DATE			TITLE SCALE
	07.0	04.17	-	BUSHING 1:1,
	Α		96.09.16	NEW ISSUE
	В		07.04.17	UPDATE NOTES





D2570 BUSHING

D2570 BUSHING

MATERIAL: 1)

AISI 303 ROUND BAR (REF. DART SPEC. M303R)

2) FINISH: NONE

3) ALL DIMENSIONS ARE INCHES

4)

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

BREAK ALL UNMARKED SHARP EDGES TO 0.010 MAX

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